

Work Order ID 113528

February-20-14 7:34:58 AM

slp 27/02

113528

Page 1

Item ID: D412-711-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Vertical Reference Door Modification LH

Stop

NS2

Start Date: 2/27/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/27/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-711

H

100

0.00

100

DOCUMENT CONTROL

DC

Memo M.A.

0.00

DAS
6
9-89

14-2-25

Doc.Control -USB or Paperwork

Photocopy bluefiles and create labels per PPP D412-711-021 CHG001

120

Pick Kit

0.00

120

Purchasing

Packaging

Memo

0.00

DAS
28
9-89

1x

14-02-21

DAS
31
9-89

Packaging

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Memo

0.00

DAS
6
9-89

14-2-25

1x

Quality Control

Work Order ID 113528

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Page 2

Item ID: D412-711-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/27/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-711-021								
	Location: <u>SHP</u>								
	PPP rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

R 14-2-23 DAS
6
9-89

MLJ 14-02-25

A 14-02-25

Picklist Print

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Work Order ID: 113528

113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

D4165-3

Manufactured No

120

Each

6.0000

1

D4165-3

Inner Door Panel

DAS

6

9-89

Location

Loc Qty

Loc Code

ST205

3

106408

3

ST206

3

109159

3

**

DAS

28

9-89

14-02-24

DAS

31

9-89

D4165-5

Manufactured No

120

Each

6.0000

1

D4165-5

Aft Rib

DAS

6

9-89

Location

Loc Qty

Loc Code

ST206

6

106421

3

109160

3

**

DAS

28

9-89

DAS

31

9-89

D4165-7

Manufactured No

120

Each

3.0000

1

D4165-7

Fwd Rib

DAS

6

9-89

Location

Loc Qty

Loc Code

ST206

3

106373

3

**

DAS

28

9-89

D4165-9

Manufactured No

120

Each

2.0000

1

D4165-9

Angle

DAS

6

9-89

Location

Loc Qty

Loc Code

ST206

2

109570

2

**

DAS

28

9-89

DAS

31

9-89

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Work Order ID: 113528

113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

D4165-11	Manufactured	No	120	Each	9.0000	1	1	DAS 28 9-89	14-02-24
D4165-11									
Door Cover Panel									
DAS 6 9-89									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	ST206		9						
	106344		9						
D4207-1	Manufactured	No	120	Each	2.0000	1	1	DAS 28 9-89	
D4207-1									
Window Retainer									
DAS 6 9-89									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	ST206		2						
	106392		1						
	109537		1						
D4207-3	Manufactured	No	120	Each	5.0000	1	1	DAS 28 9-89	
D4207-3									
Instrument Window									
DAS 6 9-89									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	ST206		5						
	101815		2						
	106327		3						
D4269-1	Manufactured	No	120	Each	1.0000	1	1	DAS 28 9-89	
D4269-1									
Angle									
DAS 6 9-89									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	ST068		1						
	109429		1						

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113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

D4269-3 Manufactured No

120 Each

6.0000

1

D4269-3

Angle

**

DAS
28
9-89

14-02-24

DAS
6
9-89

Location

Loc Qty

Loc Code

ST098

6

109569

6

D4269-5 Manufactured No

120 Each

1.0000

1

D4269-5

Angle

**

DAS
28
9-89

DAS
31
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST206

1

109462

1

D4269-7 Manufactured No

120 Each

1.0000

1

D4269-7

Angle

**

DAS
28
9-89

DAS
31
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST

1

109466

1

D4324-041 Manufactured No

120 Each

1.0000

1

D4324-041

Armrest Assembly

**

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST103

1

84221

1

D4324-043 Manufactured No

120 Each

0.0000

1

D4324-043

Arm Support Assy

**

DAS
28
9-89

DAS
31
9-89

DAS
6
9-89

113531

113506

DAS
31
9-89

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Work Order ID: 113528

113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

D4327-1
D4327-1
Angle

Manufactured No

120 Each

2.0000

1 1

DAS
28
9-89

14-02-24

DAS
1
9-89

Location
ST206

Loc Qty
2

Loc Code

109522
79133

1
1

1X

DAS
31
9-89

D4327-3
D4327-3
Angle

Manufactured No

120 Each

1.0000

1 1

DAS
28
9-89

DAS
6
9-89

Location
ST206

Loc Qty
1

Loc Code

106389

1

1X

DAS
31
9-89

D4385-1
D4385-1
Placard

Manufactured No

120 Each

8.0000

2 2

DAS
28
9-89

DAS
8
9-89

Location
ST104

Loc Qty
8

Loc Code

106367
84641

6
2

2X

DAS
31
9-89

AN3-3A
AN3-3A
Bolt

Purchased No

120 Each

379.0000

22 22

DAS
28
9-89

DAS
6
9-89

Location
st350

Loc Qty
181

Loc Code

m126249
m127044
m127815

1
197
181

22X

DAS
31
9-89

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113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

AN3-4A Purchased No 120 Each 262.0000 20 20

AN3-4A

Bolt
DAS
6
9-89

Location

Loc Qty

Loc Code

ST511

262

m127044

262

106.0000

**

DAS
28
9-89

14-02-21

AN3-6A Purchased No 120 Each 106.0000 26 26

AN3-6A

Bolt

Location

Loc Qty

Loc Code

ST511

106

M127044

106

44.0000

**

DAS
28
9-89

AN3-12A Purchased No 120 Each 44.0000 1 1

AN3-12A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

ST511

44

m125709

44

5,818.000

**

DAS
28
9-89

NAS1149F0332P Purchased No 120 Each 5,818.000 92 92

NAS1149F0332P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

12

123900

12

ST510a

5601

125646

3101

m127831

2500

**

DAS
28
9-89

DAS
31
9-89

92x

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1911

1912

1913

1914

Picklist Print

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Work Order ID: 113528

113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

CR3242-4-2

Purchased

No

120

Each

186.0000

34

34

DAS
28
9-89

14-02-21

CR3242-4-2

RIVET

DAS
6
9-89

Location

Loc Qty

Loc Code

ST329

186

117423

86

m127304

100

MS20426AD3-3

Purchased

No

120

Each

2,159.000

135

135

DAS
28
9-89

MS20426AD3-3

RIVET

DAS
6
9-89

Location

Loc Qty

Loc Code

ST334

2159

123352

2159

MS20426AD4-3

Purchased

No

120

Each

4,971.000

140

140

DAS
28
9-89

MS20426AD4-3

Rivet

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1971

113064

1971

ST334

3000

m125807

3000

MS20470AD3-3

Purchased

No

120

Each

7,146.000

25

25

DAS
28
9-89

MS20470AD3-3

RIVET, UNIVERSAL HEAD

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

742

1065

742

ST335

6404

16941

6404

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113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-3

Purchased

No

120

Each

5,489.000

90

90

MS20470AD4-3

Rivet - Universal Head

DAS
28
9-89

14-02-21

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1516

1642

73

2193

1443

ST335

3973

2193

3973

MS21042L3

Purchased

No

120

Each

3,940.000

24

24

MS21042L3

Nut

DAS
28
9-89

90x

DAS
6
9-89

Location

Loc Qty

Loc Code

ST314

2985

M127410

2934

M127831

41

xxxxx

10

ST506

955

123900

955

MS21059L3

Purchased

No

120

Each

119.0000

4

4

MS21059L3

Nut Plate

DAS
28
9-89

24x

DAS
6
9-89

Location

Loc Qty

Loc Code

ST315

100

M127916

100

ST316

19

M127743

19

4x

DAS
31
9-89

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Work Order ID: 113528

113528

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

MS21069L3

Purchased No

120 Each

62.0000

34 34

MS21069L3

ANCHOR NUT

**

DAS

28

9-89

14-02-21

Location

Loc Qty

Loc Code

ST317

62

m127255

46

m127813

16

MS21069L08

Purchased No

120 Each

1,884.000

8 8

MS21069L08

ANCHOR NUT

**

DAS

28

9-89

Location

Loc Qty

Loc Code

ST317

1884

123522

1884

MS21071L3

Purchased No

120 Each

240.0000

3 3

MS21071L3

ANCHOR NUT

**

DAS

28

9-89

Location

Loc Qty

Loc Code

ST317

240

114348

50

123301

40

124291

50

125654

100

MS21071L08

Purchased No

120 Each

258.0000

1 1

MS21071L08

ANCHOR NUT

**

DAS

28

9-89

Location

Loc Qty

Loc Code

ST318

258

102587

158

103447

100

MS21071L08

Purchased No

120 Each

258.0000

1 1

ANCHOR NUT

**

DAS

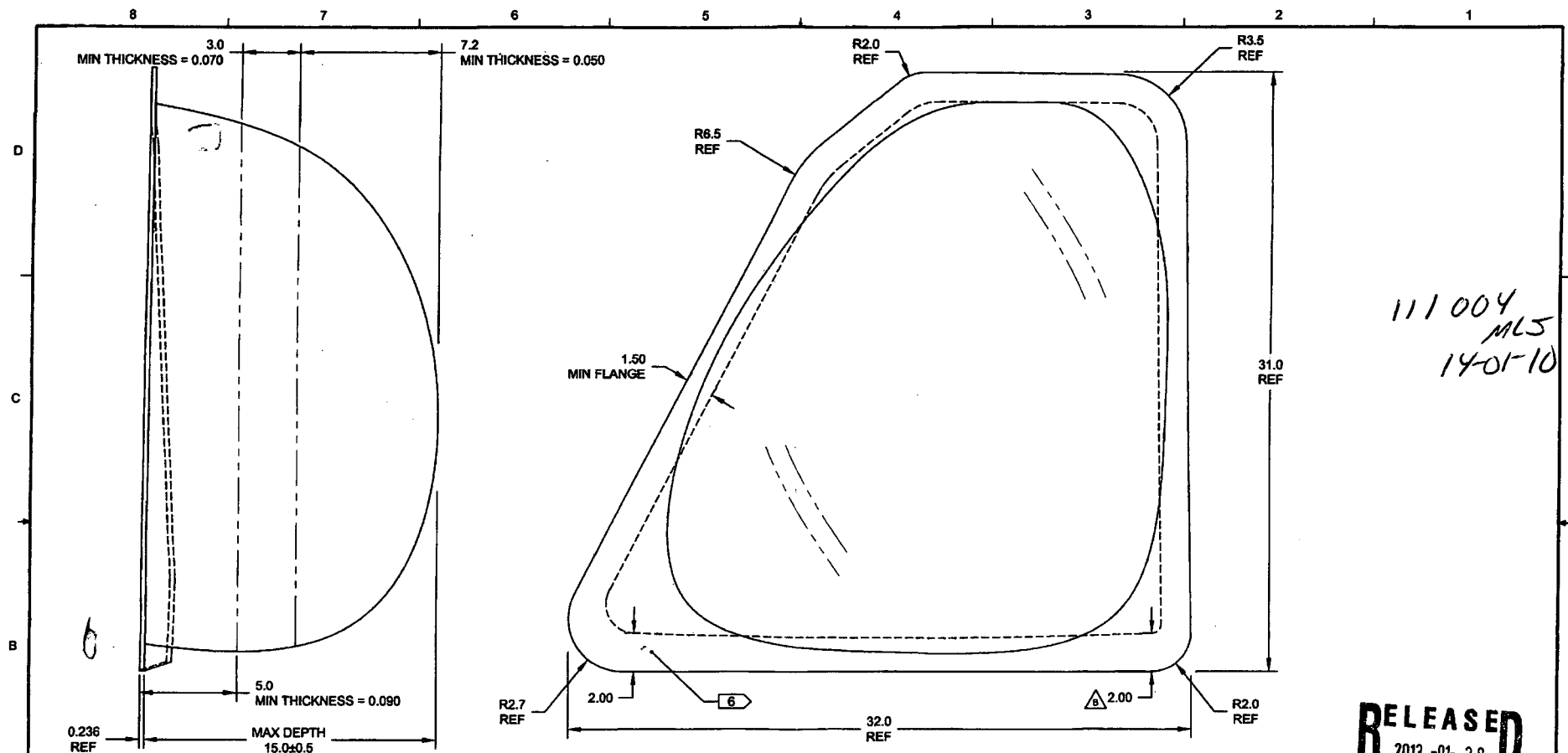
31

9-89

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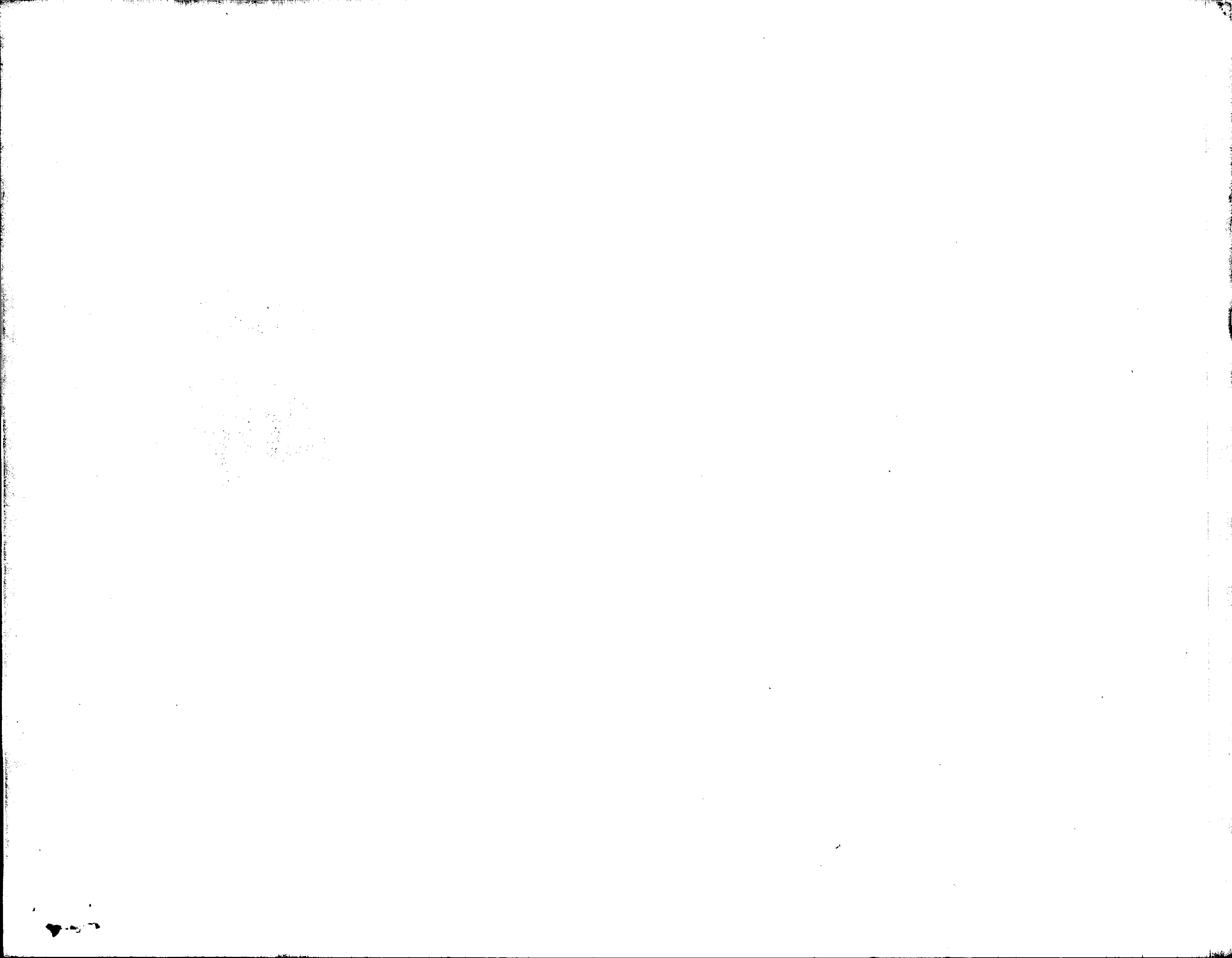


D412-711-101 REPLACEMENT WINDOW

NOTES:

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
0.236 THICK (STOCK, REF. DART SPEC. M-ACRYLIC-S-236)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D412-711-101" & B/N "BXXXXX" ON THE INSIDE SURFACE
OF THE BUBBLE WINDOW FLANGE, WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"
- 7) WEIGHT: 8.0 lbs
- 8) VACUUM FORMING: PER FOLIO FTA077 USING DT9840 MOLD AND DART QSI 022

B	REMOVED 1.73" DIM (ZN B4-1). SEE PREVIOUS REV. FOR DETAILS. 2.00 WAS 1.98 (ZN B3-1) REF CIR12-6	SFM	12.12.24
A	NEW ISSUE	MB	10.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	DS	D412-711-101	SHEET 1 OF 1
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	REPLACEMENT WINDOW	NTS
DATE	12.12.24	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
A ₁	A ₁	A ₁	A ₁	A ₁		1	204-030-853-119	LH COPILOT DOOR
1							D412-711-111	WIRING HARNESS, 212/412
B ₁							D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B ₁						D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B ₁					EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B ₁				EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B ₁			D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

(A) CUSTOMER SUPPLIED

(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210/214 Wiring Harnesses, use drawing D2046904.
 For Bell 212 Wiring Harnesses, use drawing D2046903.
 For Bell 412 Wiring Harnesses, use drawing D412-711-901.
 For Bell 212 modified per SH07-28/SR02831NY use D212-761-224
 or D212-761-225 depending on aircraft s/n.

Wiring Harnesses will vary
depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VERTICAL REFERENCE DOOR NTS	
DATE	11.05.04	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
1	1	1	1	1	X			D412-711-021	VERTICAL REFERENCE DOOR KIT
						X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1			D412-711-104	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1			D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1			D4165-1	DOUBLER
					1			D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1			* D4165-5	AFT RIB (REPLACES EA20469-34)
					1			* D4165-7	FWD RIB (REPLACES EA20469-31)
					1			D4165-9	ANGLE (REPLACES EA20469-17)
					1			D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1			D4207-1	WINDOW RETAINER (REPLACES EA20469-14)
					1			D4207-3	WINDOW (REPLACES EA20469-13)
					1			* D4269-1	ANGLE (REPLACES EA20469-33)
					1			* D4269-3	ANGLE (REPLACES EA20469-30)
					1			** D4269-5	ANGLE (REPLACES EA20469-29)
					1			* D4269-7	ANGLE (REPLACES EA20469-32)
					1			* D4324-041	ARM REST ASSEMBLY
					1			* D4324-043	ARM SUPPORT ASSEMBLY
					1			D4327-1	ANGLE (REPLACES EA20469-11)
					1			D4327-3	ANGLE (REPLACES EA20469-07)
					2			D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY
** PART OF EA20469-12 FWD RIB ASSEMBLY
*** PART OF EA20469-16 ARM REST ASSEMBLY

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